

Date: Thursday, 10/25/2007 10:12:42 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASS'Y
Job Number	: 35371		
Estimate Number	: 12525		
P.O. Number	: <u>N/A</u>	Part Number	: D3531041
This Issue	: 10/25/2007	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D3531 REV A
First Issue	: <u>N/A</u>	Project Number	: N/A
Previous Run	: 34804	Drawing Revision	: A
		Material	: <u>N/A</u>
		Due Date	: 11/10/2007
Written By	: <u>[Signature]</u>	Qty:	9 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev: A New Issue 07-09-24 EC verified DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D35311	BRACKET
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 BRACKET  
 Batch: B35378 mf

2.0	D35313	BRACKET FRONT PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 BRACKET FRONT PLATE  
 Batch: B35379 mf

3.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)  
 Rivet, Universal Head  
m105125 mf 07-11-05

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Assemble as per dwg D3531  
mf 07-11-05 (9)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP  
mf 07-11-05 (9)

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3  
mf 07/11/12 (9)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/11/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-06	4.	Two parts had each with a rivet that was <del>correct</del> installed wrong. R.C. Hummer error.	UE 07-11-08 Q51042	<del>Drill out existing rivet and</del> Put 2 rivets in MS 20470 AD 5-6 # B 2421 <u>Change</u>	MF 07-11-05	 Atulog	UE 07-11-08 Q51042	 Atulog
		Install larger rivets						

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:12:42 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 35371

Part Number: D3531041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(9X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-J 07/14/13

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57230

Ce 7/14/13 (9)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(9)

Comment: FINAL INSPECTION/W/O RELEASE

Dox 11/14

Job Completion



4 07.11.13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

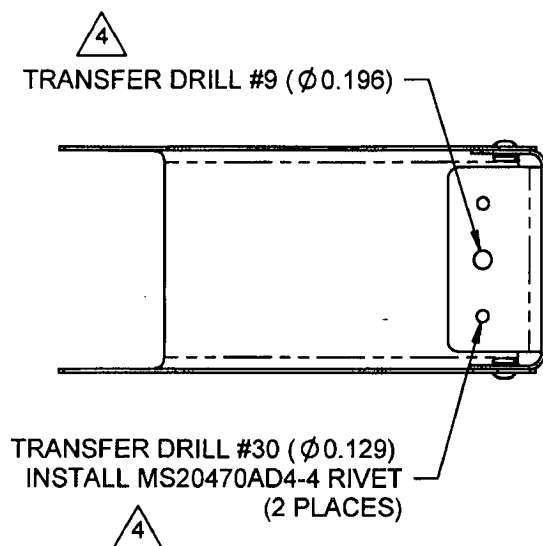
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

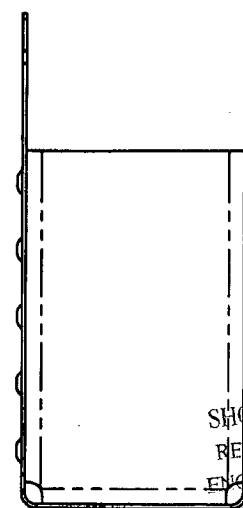
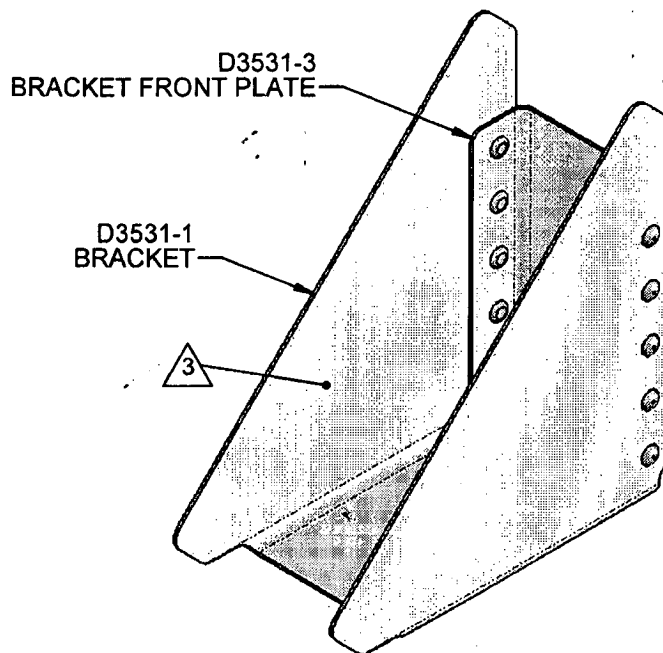
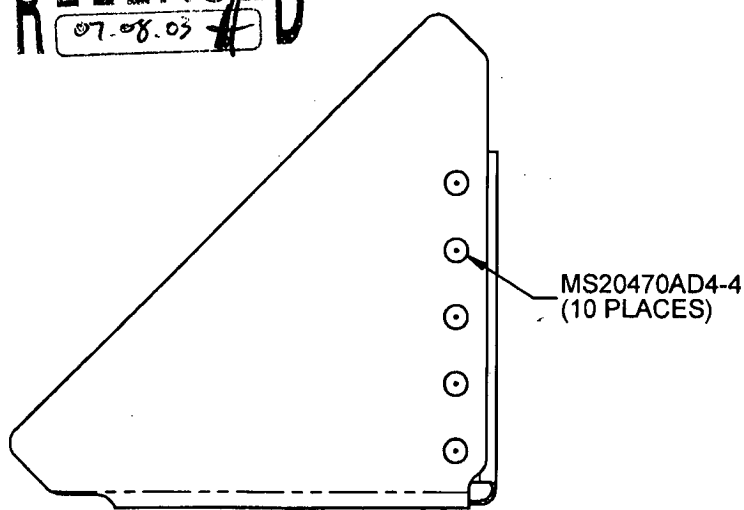
**NOTE:** Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	



RELEASED  
07.08.03



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NO. 35371

### D3531-041 BRACKET ASSEMBLY

#### NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING  
WHITE MARKER ON INSIDE OF BRACKET  
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET  
THROUGH D3531-3 BRACKET FRONT PLATE  
BEFORE FINISHING

#### PARTS LIST

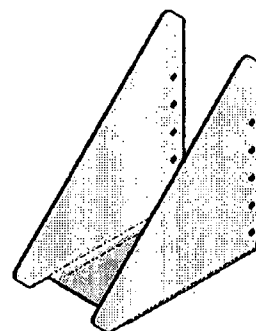
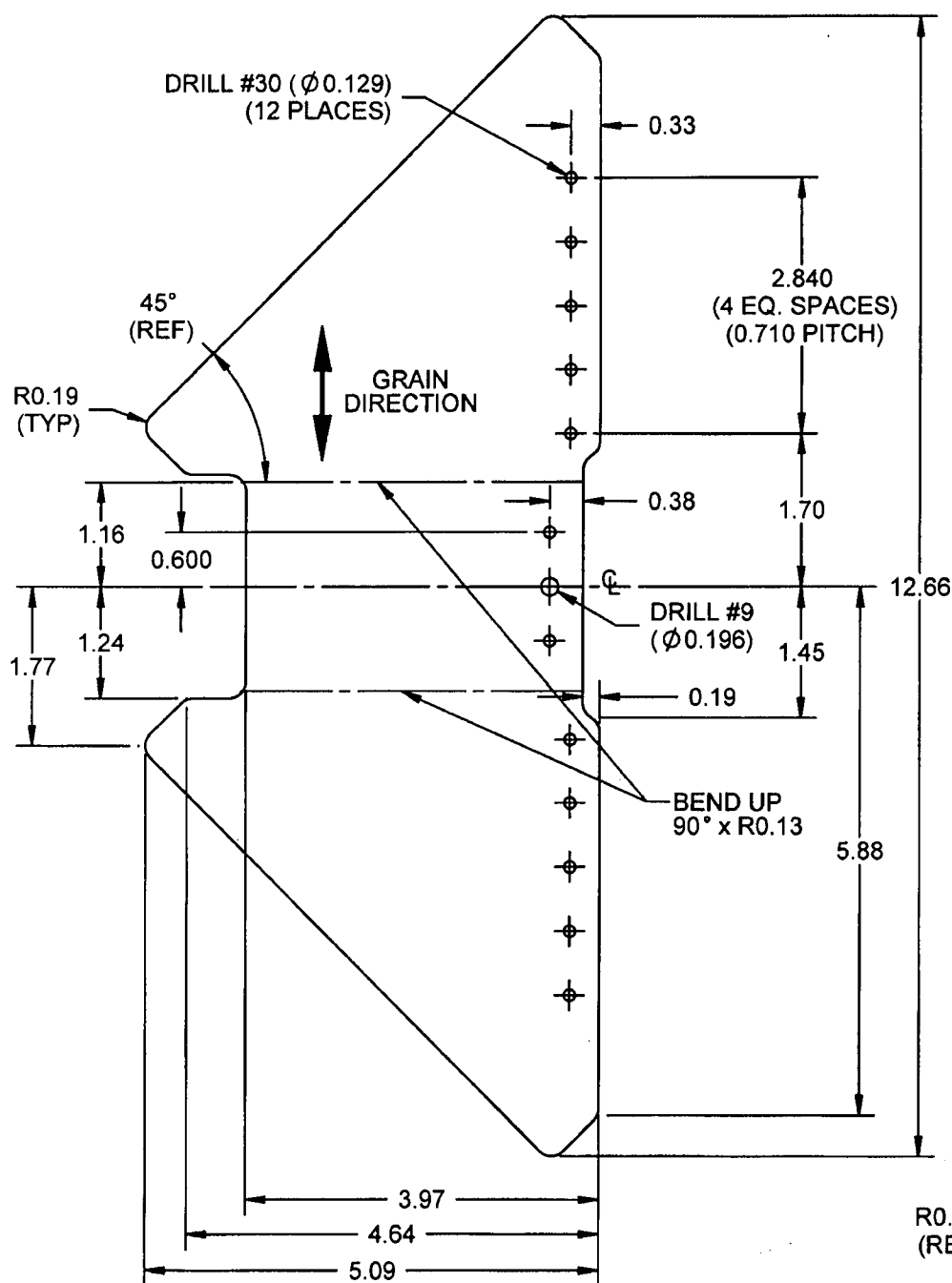
QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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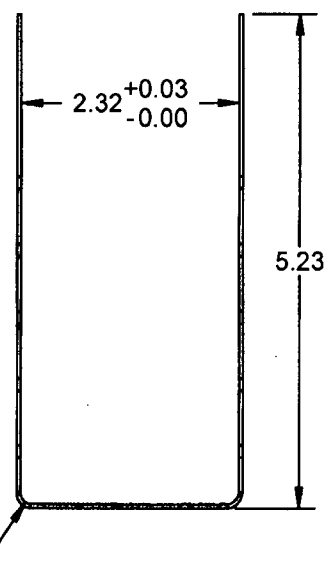
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DATE <b>07.06.19</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:2



**RELEASED**  
07-08-03



### D3531-1F FLAT PATTERN

#### NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

### D3531-1 BRACKET

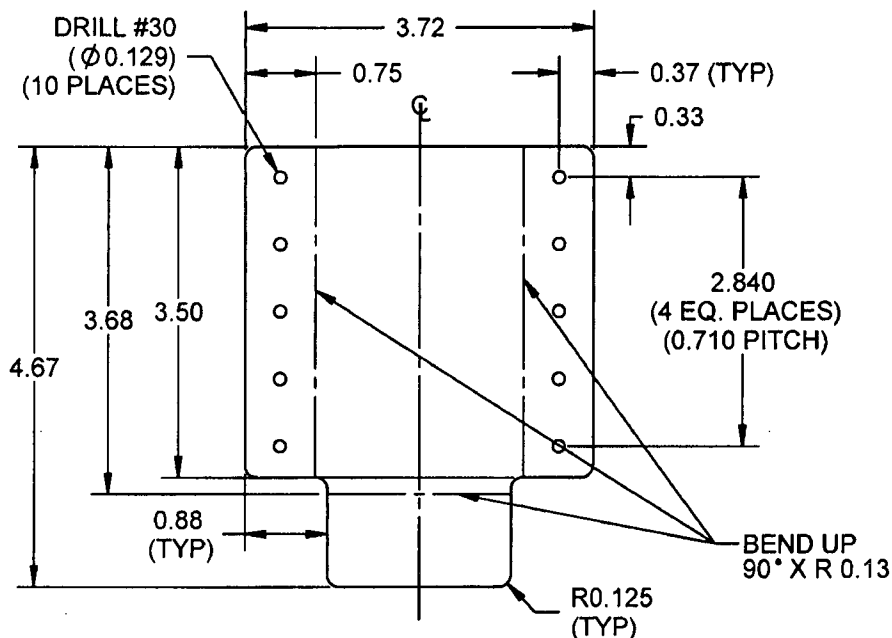
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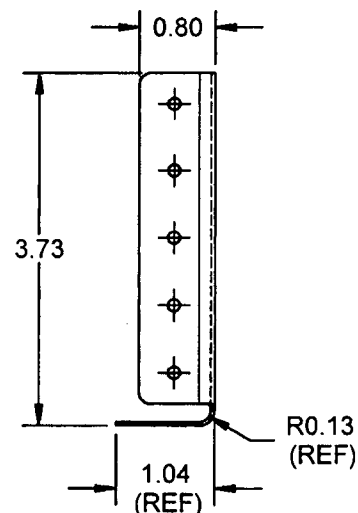
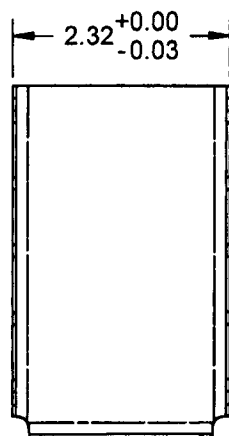
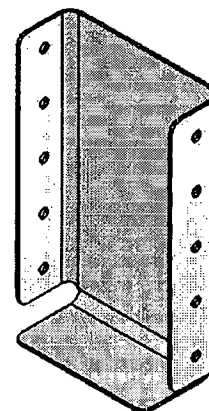


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DATE <b>07.06.19</b>	TITLE <b>BRACKET ASSEMBLY</b>	REV. A SHEET 3 OF 3 SCALE 1:2



**D3531-3F FLAT PATTERN**

**RELEASED**  
07.08.03 **#**



**D3531-3 BRACKET FRONT PLATE**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

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